



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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Reprint

D2617-5

Job Sheet 207196



Part No: D2617-5

Job Qty: 150 pcs

Part Name: Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/19/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 6/2/20

Type: SOLD

Description:

Note: DWG REV D2 IPP H 04.07.14 Reformat; added step 5 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	150 pcs		6/2/20	0.50	5.26	Hardinge - 1	<i>DAS 66 9-89</i>	<i>BM 20-03-20</i>
120	QC 8	150 pcs		6/2/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20	<i>DIP 20-03-21 / 20-03-21</i>	
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Handfinish - 1-1 Chemical-B4B	150 pcs		6/2/20	0.00	2.25	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		<i>BEB 20-03-23</i>



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Container No: S265361



Part: D2617-5

Job No: 207196

Serial No/Batch: S265361

Revision:

Inspector:

Exp Date:

Instructions: Certificate of Conformance only

					Handfinish - 1 - 3 - B4B						
					Handfinish - 1 - 4 - B4B						
					Handfinish - 1 - 5 - B4B						
					Handfinish - 1 - 6 - B4B						
					Handfinish - 1 - 7 - B4B						
					Handfinish - 1 - 8 - B4B						
					Handfinish - 1 - 9 - B4B						
					Handfinish - 1 - 10 - B4B						
					Handfinish - 1 - 11 - B4B						
					Handfinish - 1 - 12 - B4B						
					Handfinish - 1 - 13 - B4B						
					Handfinish - 1 - 14 - B4B						
					Handfinish - 1 - 15 - B4B						
					Handfinish - 1 - 16 - B4B						
					Handfinish - 1 - 17 - B4B						
					Handfinish - 1 - 18 - B4B						
					Handfinish - 1 - 19 - B4B						
					Handfinish - 1 - 20 - B4B						
					Handfinish - 1 - 21 - B4B						
					Handfinish - 1 - 22 - B4B						
					140 QC 7	150 pcs	6/2/20	0.00	0.00	QC 7 - 10	
										QC 7 - 13	
QC 7 - 14											
QC 7 - 15											
QC 7 - 17											
QC 7 - 18											
QC 7 - 19											
QC 7 - 2											
QC 7 - 28											
QC 7 - 3											
QC 7 - 30											
QC 7 - 34											
QC 7 - 36											
QC 7 - 37											
QC 7 - 41											
QC 7 - 47											
QC 7 - 48											
QC 7 - 51											
QC 7 - 58											
QC 7 - 59											
QC 7 - 60											
QC 7 - 9											
QC 7 - 68											
QC 7 - 50											
QC 7 - 67											
QC 7 - 40											
QC 7 - 24											
QC 7 - 43											
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DAS
43
MAR 23 2020 8:30

					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
					QC 7 - 83	
					QC 7 - 82	
150	Packaging 3-1 - Stock - B4B	150 ✓ pcs	6/2/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	ST008 DAS 80
					Packaging 3 - 4 - B4B	0.88
					Packaging 3 - 5 - B4B	MAR 23 2020
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 37 - B4B	
160	QC 21 - SA	150 ✓ pcs	6/2/20	0.00 0.00	QC 21 - SA - 21 ✓	ST008
					QC 21 - SA - 70	DAS
					QC 21 - SA - 53	21
					Broussard	MAR 23 2020

Part Op 100 - ***REMOVE ALL PART MARKINGS BEFORE MACHINING*** 1-Machine as per Folio FA438 and Dwg D2617 2-Descriptions: Deburr

120 - QC8- Inspect parts - second check
130 - Chemical Conversion Coat per QSI005 4.1
140 - QC7-Inspect Chemical Conversion Coat
150 - Identify as per dwg & Stock Location:
160 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.500W.058	6061-T6 Round Tube .500 X.058W	3.9900 ft (.0266 ea)	100-Hardinge - 1	S154972

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M6061T6T0.500W.058	4	199	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.223inches + 0.000 - 0.010	0.223 0.213	0.219	
2	Bushing	0.500inches ± 0.010	0.510 0.490	0.495	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					